

5/32

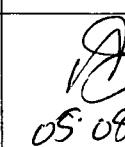
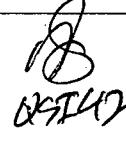
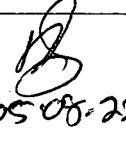
DART AEROSPACE LTD	Work Order:	23822
Description: Ø2.750 Support	Part Number:	D2893-1
Dwg: D2893 Rev. A1	Qty:	724
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2893-1 Dwg not required	PF	05.07.15	22
2	PG	Issue P/O: Description: D6104-005 USE stock B 23232 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required.			
3	RG	Receive and Inspect for raw material dimensions. Ensure material release note is attached.	N/A		
4	MS	Turn blank for Haas as per Folio FA081	SG	05/08/11	22
5	QC1	Inspect all dimensions as per Dwg D2893	SG	05/08/13	22
6	MV	Machine as per Folio FA081	Er	05/08/22	20
7	MV	Tumble & Deburr	CP	05/08/22	20
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2893	CP	05/08/22	20
9	QC8	Inspect dimensions for second check	M	05/08/22	20
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	M	05/08/24	20
11	QC3	Inspect Powder Coat	DL	05/08/24	20
12	ST	Identify and stock	DL	05/08/24	20
13	AC	Cost / part 96.89	SG	05/08/25	20
14	DC	Close W/O / 09.54 Inspect Level 21	DB	05/09/25	20

Rev	Date	Change	Revised By	Approved
A	01.01.08	Preliminary Issue	EC	
B	01.07.19	Heat treat removed	NG	
C	02.11.26	Reformat; Added P/O	KJ / RF	RF

RELEASED
02.11.29 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
0508.19	6	- 1 part moved on jig "not tight enough" - holes are not aligned	 05/08/22	destroy piece	5 05/08/22	 05.08.22	 05/08/22	 05 08 22

Part No: D2823-1PAR #: 132Fault Category: PTTNCR: Yes No DQA: SDDate: 05/08/22

NOTE: Date & initial all entries

Production / FAB Pass
QA: N/C Closed: SD

Date: _____

DART AEROSPACE LTD	Work Order:	23822
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
Lathe Section										
A	2.707	2.712		2.702	2.712	2.711	2.712			
B	4.946	4.966		4.952	4.951	4.950	4.950			
C	3.064	3.084		3.074	3.075	3.075	3.074			
D	0.718	0.738		0.725	0.726	0.727	0.726			
E	0.090	0.110		0.098	0.098	0.099	0.098			
F	2.934	2.954		2.944	2.944	2.944	2.944			
G	2.166	2.186		2.171	2.173	2.171	2.172			
H	3.890	3.910		3.900	3.900	3.900	3.900			
I	0.914	0.934		0.924	0.928	0.927	0.927			
J	0.022	0.042		0.032	0.032	0.032	0.032			
K	0.109	0.129		0.117	0.117	0.117	0.118			
L										
HAAS Section										
AA	2.985	3.005		2.992	2.997	2.996	2.996			
AB	0.440	0.460		0.450	0.450	0.450	0.450			
AC	0.125	0.160		0.145	0.146	0.148	0.149			
AD	0.040	0.060		0.045	0.042	0.042	0.042			
AE	0.188	0.193	DT8706							
AF	0.125	0.160		0.145	0.140	0.143	0.143			
AG	0.140	0.160		0.144	0.145	0.147	0.144			
AH	1.360	1.400		1.375	1.380	1.378	1.380			
AI	0.040	0.060		0.051	0.050	0.053	0.050			
AJ	1.190	1.230		1.220	1.221	1.221	1.221			
AK	0.010	0.020		0.010	0.010	0.010	0.010			
AL	0.053	0.073		0.063	0.063	0.063	0.063			
AM	0.240	0.260		0.250	0.250	0.250	0.250			
AN	2.518	2.538		2.528	2.538	2.528	2.528			
AO	84.39	90.39	DT8699							
AP	0.257	0.262	DT8683							
AQ	0.053	0.073		0.063	0.063	0.063	0.063			
AR										
AS										
Accept/Reject										

Measured by: J. G
Date: 05/08/13 / 05/08/21

Audited by: gml
Date: 05/08/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF <u>RF</u>	<u>RF</u>

RELEASED
03.07.01

DART AEROSPACE LTD

Work Order:

28822

Description: Ø2.750 Support

Part Number:

D2893-1

Inspection Dwg: D2893 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.711	2.710	2.709		
B	4.946	4.966		4.951	4.950	4.949	4.950		
C	3.064	3.084		3.074	3.075	3.076	3.076		
D	0.718	0.738		0.728	0.726	0.731	0.726		
E	0.090	0.110		0.098	0.098	0.100	0.098		
F	2.934	2.954		2.945	2.944	2.945	2.946		
G	2.166	2.186		2.171	2.172	2.170	2.169		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		0.924	0.925	0.930	0.930		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.109	0.129		0.117	0.118	0.116	0.117		
L									
HAAS Section									
AA	2.985	3.005		2.996	2.996	2.996	2.998		
AB	0.440	0.460		0.450	0.450	0.450	0.450		
AC	0.125	0.160		0.143	0.143	0.148	0.145		
AD	0.040	0.060		0.045	0.046	0.049	0.045		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.142	0.147	0.148	0.148		
AG	0.140	0.160		0.146	0.146	0.146	0.147		
AH	1.360	1.400		1.381	1.380	1.381	1.380		
AI	0.040	0.060		0.045	0.045	0.045	0.050		
AJ	1.190	1.230		1.218	1.218	1.220	1.217		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		2.528	2.528	2.528	2.528		
AO	84.39	90.39	DT8699					No tool to measure with	
AP	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
Accept/Reject									

Measured by: J. G / SP
 Date: 05/08/13 / 05/08/22

Audited by: GML
 Date: 05/08/22

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF RF	RF

RELEASED
 03.07.01

DART AEROSPACE LTD

Work Order:

23822

Description: Ø2.750 Support

Part Number:

D2893-1

Inspection Dwg: D2893 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	$\frac{7}{8}$	$\frac{2}{10}$	$\frac{3}{11}$	$\frac{4}{12}$	By	Date
Lathe Section									
A	2.707	2.712		2.710	2.711	2.711			
B	4.946	4.966		4.953	4.955	4.956			
C	3.064	3.084		3.074	3.074	3.075			
D	0.718	0.738		0.728	0.728	0.724			
E	0.090	0.110		0.100	0.100	0.098			
F	2.934	2.954		2.947	2.946	2.945			
G	2.166	2.186		2.167	2.171	2.171			
H	3.890	3.910		3.898	3.900	3.899			
I	0.914	0.934		0.924	0.924	0.928			
J	0.022	0.042		0.032	0.032	0.032			
K	0.109	0.129		0.117	0.118	0.117			
L									
HAAS Section									
AA	2.985	3.005		2.996	2.995				
AB	0.440	0.460		0.450	0.450				
AC	0.125	0.160		0.146	0.146				
AD	0.040	0.060		0.047	0.043				
AE	0.188	0.193	DT8706	0.188	0.188				
AF	0.125	0.160		0.146	0.147				
AG	0.140	0.160		0.148	0.143				
AH	1.360	1.400		1.374	1.380				
AI	0.040	0.060		0.050	0.050				
AJ	1.190	1.230	→	1.220	1.221				
AK	0.010	0.020		0.010	0.010				
AL	0.053	0.073		0.063	0.063				
AM	0.240	0.260		0.250	0.258	0.258			
AN	2.518	2.538		2.528	2.528				
AO	84.39	90.39	DT8699	84.39	84.39				
AP	0.257	0.262	DT8683	0.257	0.257				
AQ	0.053	0.073		0.063	0.063				
AR									
AS									
Accept/Reject									

Measured by: J. G / RF
 Date: 05/08/13 / 05/08/12

Audited by: JNL
 Date: 05/08/12

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF <u>RF</u>	<u>J</u>

RELEASED
 03.07.01 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 14, 2005
03:52 pm

Work Order No	:	0023822	Department Code:	
Project Name	:	D2893-1	Burden Flags	: NNNNNNN
Project For	:	WK532	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2893-1	Invoice Number	:
Description	:	Support	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	10	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	07-14-05	Est Mark Up	: 0.000%
Est Finish Date	:	08-15-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:			\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00